

FIG. 1

<div style="display: flex; justify-content: space-between;"> <span>◀</span> <span><b>AUTO PROCESS SETTING</b></span> <span>▶</span> </div>											
FUNCTION/TIME SETTING				FUNCTION/TIME SETTING				<div style="display: flex; align-items: center;"> <input checked="" type="checkbox"/> 2002/12/20 0:21:20         </div>			
<div style="display: flex; justify-content: space-between;"> <div>           MOVEMENT: ONE TWO THREE FOUR FIVE SIX SEVEN EIGHT NINE TEN NEXT            END OF MOLD-OPENING ▶ 02 ▶ 01 ▶ 03 ▶ 15 ▶ 04 ▶ 14 ▶ NO ▶ NO ▶ NO ▶ NO ▶ CYCLE         </div> </div>											
<div style="display: flex; justify-content: space-between;"> <div>           MOVEMENT: ONE TWO THREE FOUR FIVE            END OF MOLD-CLOSING ▶ NO ▶ 01 ▶ NO ▶ NO ▶ NO ▶            NO(NO MOVEMENT) <span style="border: 1px solid black; padding: 0 10px;"> </span> NO(NO MOVEMENT) <span style="border: 1px solid black; padding: 0 10px;"> </span> NO(NO MOVEMENT)         </div> <div>MOLD-OPEN</div> </div> <div style="display: flex; justify-content: space-between; margin-top: 5px;"> <div>1. MID-EJ-BWD 2. GATE-VA ON</div> <div>1. MID-EJ-BWD 2. GATE-VA OFF</div> <div>1. MID-EJ-BWD 2. GATE-VA ON</div> <div>1. MID-EJ-BWD 2. GATE-VA OFF</div> </div>											
<div style="border: 1px solid black; padding: 2px;">OPTIONS AFTER END OF MOLD-CLOSING</div> <div style="font-size: 0.8em;">           NO. NO MOVEMENT 6. CORE ONE OUT 12. ROTA-FWD CORE-1-F.B.            1. ROTATE MODE 7. CORE ONE IN ROTA-BWD CORE-2-F.B.            2. MID-EFJ-FWD 8. CORE TWO OUT 13. FR-BA-EJ-BWD            3. MID-EJ-BWD 9. CORE TWO IN 14. CYC-END            4. FR-BA-EJ 10. GATE-VA OFF 15. OP-CL-DOOR            5. MID-FR-EJ 11. BATE-VA ON         </div>						<div style="border: 1px solid black; height: 20px; margin-bottom: 5px;"></div> <div style="font-size: 0.8em;">           NO. (NO MOVE)            1. BI-COLOR INJ.            2. FRONT INJ. <span style="border: 1px solid black; padding: 0 10px;"> </span> IN SEQUENCE            3. REAR INJ. <span style="border: 1px solid black; padding: 0 10px;"> </span>  <div style="display: flex; align-items: center;"> <div style="border: 1px solid black; padding: 2px;">POSITION OF ROTARY PLATE</div> <span style="border: 1px solid black; padding: 0 10px;"> </span> </div> </div>					
<div style="display: flex; justify-content: space-between; align-items: center;"> <div> <div style="border: 1px solid black; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center;"> </div> <div style="border: 1px solid black; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center;"> </div> <div style="border: 1px solid black; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center;"> </div> <div style="border: 1px solid black; width: 20px; height: 20px; display: flex; align-items: center; justify-content: center;"> </div> </div> <div style="border: 1px solid black; flex-grow: 1; margin-left: 10px;"></div> </div>											

FIG. 2

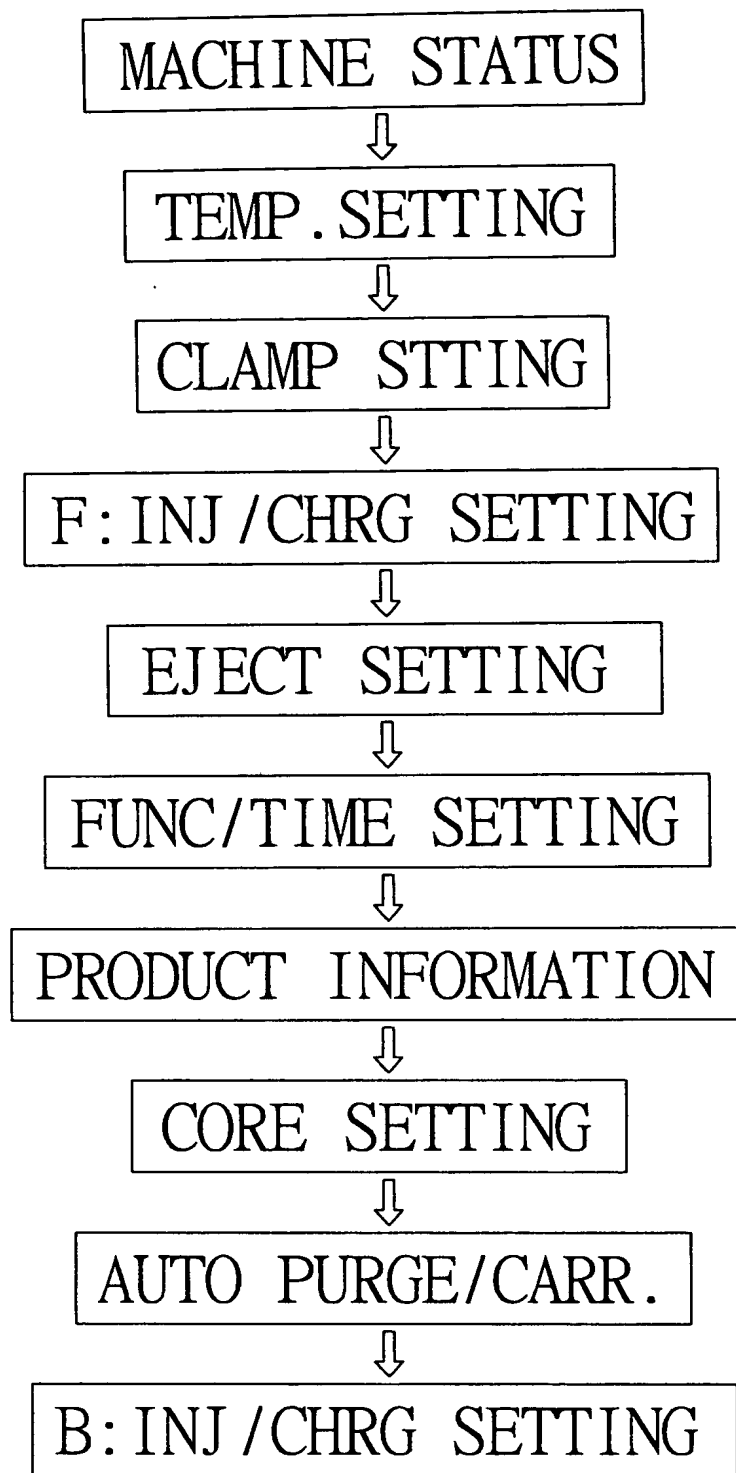


FIG. 3 (PRIOR ART)

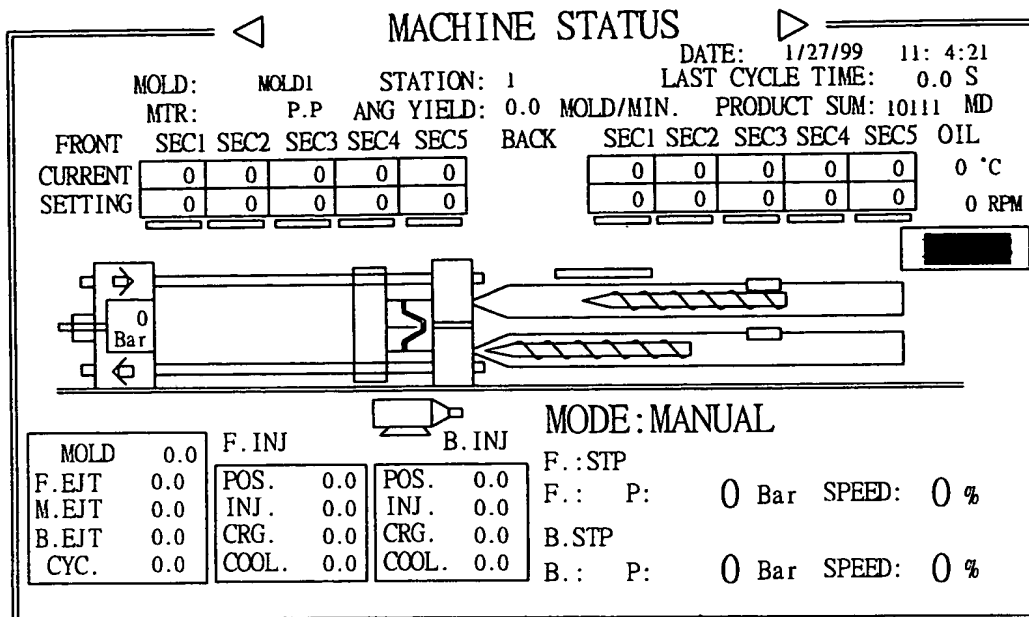


FIG. 4 (PRIOR ART)

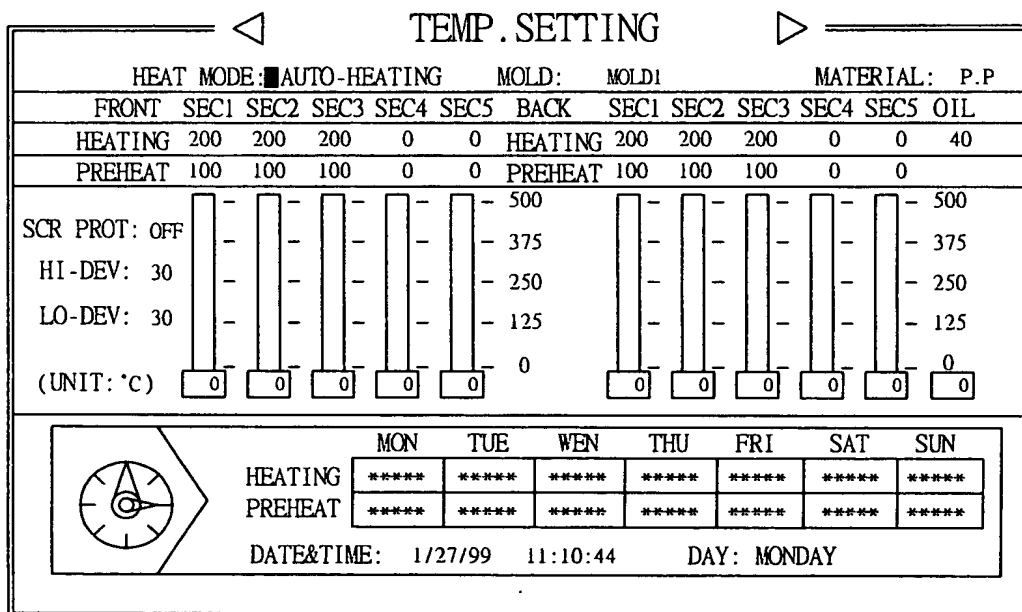


FIG. 5 (PRIOR ART)

**CLAMP SETTING**

MOLD: MOLD1 L\_P\_T: 0.0 S MOLD POS: 0.0 mm

<b>CLAMP-P</b> <div style="border: 1px solid black; padding: 2px; text-align: center;">0</div> Bar 	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th></th> <th>FAST</th> <th>SLOW</th> <th>L-P</th> <th>H-P</th> <th></th> </tr> <tr> <td>PRES</td> <td style="background-color: black;"> </td> <td>30</td> <td> </td> <td>140</td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td>99</td> <td>50</td> <td>40</td> <td>99</td> <td>%</td> </tr> <tr> <td>POS.</td> <td>160</td> <td> </td> <td>100</td> <td>0.5</td> <td>mm</td> </tr> </table> <p>L_P_PROT: 6.0 sec FAST CLAMP: OFF CLAMP FORCE: 360 TON</p>		FAST	SLOW	L-P	H-P		PRES		30		140	Bar	SPEED	99	50	40	99	%	POS.	160		100	0.5	mm
	FAST	SLOW	L-P	H-P																					
PRES		30		140	Bar																				
SPEED	99	50	40	99	%																				
POS.	160		100	0.5	mm																				
<b>OPEN</b> 	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th></th> <th>DEC.</th> <th>MID</th> <th>FAST</th> <th>SLOW</th> <th></th> </tr> <tr> <td>PRES</td> <td>30</td> <td>30</td> <td>30</td> <td>140</td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td>99</td> <td>50</td> <td>40</td> <td>99</td> <td>%</td> </tr> <tr> <td>POS.</td> <td>600</td> <td>540</td> <td>50</td> <td>50</td> <td>mm</td> </tr> </table> <p>OP-LIM.: 1000 mm OP_MD_PROT: 5.0 sec SPRING MOLD: OFF</p>		DEC.	MID	FAST	SLOW		PRES	30	30	30	140	Bar	SPEED	99	50	40	99	%	POS.	600	540	50	50	mm
	DEC.	MID	FAST	SLOW																					
PRES	30	30	30	140	Bar																				
SPEED	99	50	40	99	%																				
POS.	600	540	50	50	mm																				
<b>MOLD-ADJ.</b> 	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th></th> <th>MV-BWD</th> <th>CLAMP</th> <th>MV-FWD</th> <th></th> </tr> <tr> <td>PRES</td> <td>40</td> <td>40</td> <td>40</td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td>30</td> <td>20</td> <td>30</td> <td>%</td> </tr> <tr> <td>PS</td> <td>0</td> <td> </td> <td> </td> <td> </td> </tr> </table>		MV-BWD	CLAMP	MV-FWD		PRES	40	40	40	Bar	SPEED	30	20	30	%	PS	0							
	MV-BWD	CLAMP	MV-FWD																						
PRES	40	40	40	Bar																					
SPEED	30	20	30	%																					
PS	0																								

FIG. 6(PRIOR ART)

**F: INJ /CHRG SETTING**

CHRG LIMIT: 470.0 mm INJ. POS.: 0.0

INJECTION USE: ☒ OFF SUCK MODE: OFF COOL TM: 0.0

<b>INJECTION</b> 	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th></th> <th>HOLD2</th> <th>HOLD1</th> <th>INJ3</th> <th>INJ2</th> <th>INJ1</th> <th></th> </tr> <tr> <td>PRES</td> <td>0</td> <td>10</td> <td>0</td> <td>0</td> <td>60</td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td>0</td> <td>20</td> <td>0</td> <td>0</td> <td>80</td> <td>%</td> </tr> <tr> <td>TIME</td> <td>0.0</td> <td>0.5</td> <td> </td> <td>0.60</td> <td> </td> <td>sec</td> </tr> <tr> <td>POS.</td> <td>*****</td> <td> </td> <td>0.0</td> <td>0.0</td> <td>10.0</td> <td>mm</td> </tr> </table>		HOLD2	HOLD1	INJ3	INJ2	INJ1		PRES	0	10	0	0	60	Bar	SPEED	0	20	0	0	80	%	TIME	0.0	0.5		0.60		sec	POS.	*****		0.0	0.0	10.0	mm
	HOLD2	HOLD1	INJ3	INJ2	INJ1																															
PRES	0	10	0	0	60	Bar																														
SPEED	0	20	0	0	80	%																														
TIME	0.0	0.5		0.60		sec																														
POS.	*****		0.0	0.0	10.0	mm																														
<b>SHRG</b> 	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th></th> <th>CHRG1</th> <th>CHRG2</th> <th>POSTSCK</th> <th></th> </tr> <tr> <td>PRES</td> <td>0</td> <td>0</td> <td>40</td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td>0</td> <td>99</td> <td>40</td> <td>%</td> </tr> <tr> <td>SYS-PRES</td> <td> </td> <td>0</td> <td> </td> <td>Bar</td> </tr> <tr> <td>POS.</td> <td>0.0</td> <td>100.0</td> <td>0</td> <td>mm</td> </tr> </table> <p>INJ. STL MODE: POS. or TM</p>		CHRG1	CHRG2	POSTSCK		PRES	0	0	40	Bar	SPEED	0	99	40	%	SYS-PRES		0		Bar	POS.	0.0	100.0	0	mm										
	CHRG1	CHRG2	POSTSCK																																	
PRES	0	0	40	Bar																																
SPEED	0	99	40	%																																
SYS-PRES		0		Bar																																
POS.	0.0	100.0	0	mm																																
<b>CARR</b> 	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th></th> <th>FWD</th> <th>BWD</th> <th></th> <th>PRE TEST</th> <th>ACC USE</th> <th></th> </tr> <tr> <td>PRES</td> <td>20</td> <td>20</td> <td>Bar</td> <td>OFF</td> <td>OFF</td> <td>Bar</td> </tr> <tr> <td>SPEED</td> <td>20</td> <td>20</td> <td>%</td> <td>0</td> <td>10</td> <td>%</td> </tr> <tr> <td>BWD-SEL</td> <td> </td> <td>OFF</td> <td> </td> <td>0</td> <td>0</td> <td> </td> </tr> <tr> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> <td>0.0</td> <td> </td> </tr> </table>		FWD	BWD		PRE TEST	ACC USE		PRES	20	20	Bar	OFF	OFF	Bar	SPEED	20	20	%	0	10	%	BWD-SEL		OFF		0	0							0.0	
	FWD	BWD		PRE TEST	ACC USE																															
PRES	20	20	Bar	OFF	OFF	Bar																														
SPEED	20	20	%	0	10	%																														
BWD-SEL		OFF		0	0																															
					0.0																															

FIG. 7(PRIOR ART)

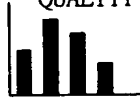
<div style="display: flex; justify-content: space-between;"> <span>◀</span> <span>EJECT SETTING</span> <span>▶</span> </div>																																													
S-EJ-F POS.: 0.0    EJ-M POS.: 0.0    S-EJ-B POS.: 0.0 mm																																													
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="2">ROTA STOP</th> <th>ROTA-B</th> <th>ROTA-S</th> <th>ROTA-F</th> <th></th> </tr> <tr> <td style="text-align: center;">0</td> <td>PRES</td> <td style="text-align: center;">140</td> <td style="text-align: center;">140</td> <td style="text-align: center;">140</td> <td>Bar</td> </tr> <tr> <td style="text-align: center;">0</td> <td>SPEED</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td>%</td> </tr> </table>					ROTA STOP		ROTA-B	ROTA-S	ROTA-F		0	PRES	140	140	140	Bar	0	SPEED	0	0	0	%	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="2">EJ-FW1</th> <th>EJ-FW2</th> <th></th> </tr> <tr> <td style="text-align: center;">40</td> <td>PRES</td> <td style="text-align: center;">40</td> <td>Bar</td> </tr> <tr> <td style="text-align: center;">60</td> <td>SPEED</td> <td style="text-align: center;">60</td> <td>%</td> </tr> <tr> <td style="text-align: center;">0.0</td> <td>POS.</td> <td style="text-align: center;">0.0</td> <td>mm</td> </tr> </table>					EJ-FW1		EJ-FW2		40	PRES	40	Bar	60	SPEED	60	%	0.0	POS.	0.0	mm		
ROTA STOP		ROTA-B	ROTA-S	ROTA-F																																									
0	PRES	140	140	140	Bar																																								
0	SPEED	0	0	0	%																																								
EJ-FW1		EJ-FW2																																											
40	PRES	40	Bar																																										
60	SPEED	60	%																																										
0.0	POS.	0.0	mm																																										
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>F. S-EJ-B</th> <th>S-EJ-F</th> <th></th> <th>B. S-EJ-B</th> <th>S-EJ-F</th> <th></th> </tr> <tr> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td>PRES</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td></td> </tr> <tr> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td>SPEED</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td></td> </tr> <tr> <td style="text-align: center;">0.0</td> <td style="text-align: center;">0.0</td> <td>POS.</td> <td style="text-align: center;">0.0</td> <td style="text-align: center;">0.0</td> <td></td> </tr> </table>					F. S-EJ-B	S-EJ-F		B. S-EJ-B	S-EJ-F		0	0	PRES	0	0		0	0	SPEED	0	0		0.0	0.0	POS.	0.0	0.0		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="2">EJ-BWD</th> <th></th> </tr> <tr> <td style="text-align: center;">60</td> <td>PRES</td> <td>Bar</td> </tr> <tr> <td style="text-align: center;">60</td> <td>SPEED</td> <td>%</td> </tr> <tr> <td style="text-align: center;">0.0</td> <td>POS.</td> <td>mm</td> </tr> </table>					EJ-BWD			60	PRES	Bar	60	SPEED	%	0.0	POS.	mm
F. S-EJ-B	S-EJ-F		B. S-EJ-B	S-EJ-F																																									
0	0	PRES	0	0																																									
0	0	SPEED	0	0																																									
0.0	0.0	POS.	0.0	0.0																																									
EJ-BWD																																													
60	PRES	Bar																																											
60	SPEED	%																																											
0.0	POS.	mm																																											
<table style="width: 100%;"> <tr> <td style="width: 33%; vertical-align: top;">           EJECT MODE: HEPEATED            EJC DELAY: 0.0 S            HOLD TIME: 0.0 S            EJC TIMES: 3            FIXED EJC: OFF         </td> <td style="width: 33%; vertical-align: top;">           ROTA MODE: OFF            S-EJ MODE: OFF            S-EJ-F TI.: 0            S-EJ-B TI.: 0            MASK TIME: OFF            PHOTOCCELL: OFF         </td> <td style="width: 33%; vertical-align: top;">           AIR EJECT: OFF            MV-MD EJ POS.: 100 mm            FIXED-MD EJ TM: 2.0 sec            MV-MD EJ TM: 2.0 sec            CLP-END-EJ: OFF         </td> </tr> </table>										EJECT MODE: HEPEATED EJC DELAY: 0.0 S HOLD TIME: 0.0 S EJC TIMES: 3 FIXED EJC: OFF	ROTA MODE: OFF S-EJ MODE: OFF S-EJ-F TI.: 0 S-EJ-B TI.: 0 MASK TIME: OFF PHOTOCCELL: OFF	AIR EJECT: OFF MV-MD EJ POS.: 100 mm FIXED-MD EJ TM: 2.0 sec MV-MD EJ TM: 2.0 sec CLP-END-EJ: OFF																																	
EJECT MODE: HEPEATED EJC DELAY: 0.0 S HOLD TIME: 0.0 S EJC TIMES: 3 FIXED EJC: OFF	ROTA MODE: OFF S-EJ MODE: OFF S-EJ-F TI.: 0 S-EJ-B TI.: 0 MASK TIME: OFF PHOTOCCELL: OFF	AIR EJECT: OFF MV-MD EJ POS.: 100 mm FIXED-MD EJ TM: 2.0 sec MV-MD EJ TM: 2.0 sec CLP-END-EJ: OFF																																											

FIG. 8 (PRIOR ART)

<div style="display: flex; justify-content: space-between;"> <span>◀</span> <span>FUNC/TIME SETTING</span> <span>▶</span> </div>							
<div style="text-align: center;"> <b>FUNC SWITCH</b>  </div>	<table style="width: 100%;"> <tr> <td style="width: 50%;">           ROBAT <input checked="" type="checkbox"/> ON            CHR-G-AFT-COOLING <input type="checkbox"/> OFF            EXHAUST <input type="checkbox"/> OFF            REV. <input type="checkbox"/> OFF         </td> <td style="width: 50%;">           P-PRE-TEST <input type="checkbox"/> OFF            PRES <input type="text" value="50"/> Bar            SPEED <input type="text" value="50"/> %         </td> </tr> </table>			ROBAT <input checked="" type="checkbox"/> ON CHR-G-AFT-COOLING <input type="checkbox"/> OFF EXHAUST <input type="checkbox"/> OFF REV. <input type="checkbox"/> OFF	P-PRE-TEST <input type="checkbox"/> OFF PRES <input type="text" value="50"/> Bar SPEED <input type="text" value="50"/> %		
ROBAT <input checked="" type="checkbox"/> ON CHR-G-AFT-COOLING <input type="checkbox"/> OFF EXHAUST <input type="checkbox"/> OFF REV. <input type="checkbox"/> OFF	P-PRE-TEST <input type="checkbox"/> OFF PRES <input type="text" value="50"/> Bar SPEED <input type="text" value="50"/> %						
<div style="text-align: center;"> <b>TIMER SETTING</b>  </div>	<table style="width: 100%;"> <tr> <td style="width: 50%;">           CYCLE ALM <input type="text" value="60.0"/> sec            INJECT ALM <input type="text" value="30.0"/> sec            CHARGE ALM <input type="text" value="30.0"/> sec            MIDDLE ALM <input type="text" value="360.0"/> sec            POWER DOOR OPN <input type="text" value="3.0"/> sec            F. INJECT ALM <input type="text" value="0.1"/> sec         </td> <td style="width: 50%;">           RECYCLE DELAY <input type="text" value="0.1"/> sec            ABNDRMAL TIME <input type="text" value="60.0"/> sec            PHOTOCCELL <input type="text" value="6.0"/> sec            EXHAUST TM <input type="text" value="0.1"/> sec            F. CHARGE ALM <input type="text" value="0.1"/> sec         </td> </tr> </table>			CYCLE ALM <input type="text" value="60.0"/> sec INJECT ALM <input type="text" value="30.0"/> sec CHARGE ALM <input type="text" value="30.0"/> sec MIDDLE ALM <input type="text" value="360.0"/> sec POWER DOOR OPN <input type="text" value="3.0"/> sec F. INJECT ALM <input type="text" value="0.1"/> sec	RECYCLE DELAY <input type="text" value="0.1"/> sec ABNDRMAL TIME <input type="text" value="60.0"/> sec PHOTOCCELL <input type="text" value="6.0"/> sec EXHAUST TM <input type="text" value="0.1"/> sec F. CHARGE ALM <input type="text" value="0.1"/> sec		
CYCLE ALM <input type="text" value="60.0"/> sec INJECT ALM <input type="text" value="30.0"/> sec CHARGE ALM <input type="text" value="30.0"/> sec MIDDLE ALM <input type="text" value="360.0"/> sec POWER DOOR OPN <input type="text" value="3.0"/> sec F. INJECT ALM <input type="text" value="0.1"/> sec	RECYCLE DELAY <input type="text" value="0.1"/> sec ABNDRMAL TIME <input type="text" value="60.0"/> sec PHOTOCCELL <input type="text" value="6.0"/> sec EXHAUST TM <input type="text" value="0.1"/> sec F. CHARGE ALM <input type="text" value="0.1"/> sec						
<div style="text-align: center;"> <b>COMMUNICATION</b>  </div>	<table style="width: 100%;"> <tr> <td style="width: 50%;">           ST_NO: <input type="text" value="1"/> </td> <td style="width: 50%;">           BAUD: <input type="text" value="9600"/> BPS         </td> </tr> <tr> <td>           PROTOCOL: <input type="text" value="PIS"/> </td> <td>           COM_FUN: DISABLE         </td> </tr> </table>			ST_NO: <input type="text" value="1"/>	BAUD: <input type="text" value="9600"/> BPS	PROTOCOL: <input type="text" value="PIS"/>	COM_FUN: DISABLE
ST_NO: <input type="text" value="1"/>	BAUD: <input type="text" value="9600"/> BPS						
PROTOCOL: <input type="text" value="PIS"/>	COM_FUN: DISABLE						

FIG. 9 (PRIOR ART)

◀
PRODUCT INFORMATION
▶

<b>QUALITY CTL</b> 	MATERIAL: <span style="background-color: black; color: black;">████████</span>		MOLD: MOLD1		SAVE	
	MOLD SEARCH:		LOAD		CLEAR	
	POWER TIME: 0 HR		AUTO-WORK T 0.0 HR			

	TOTAL_NO	GOOD_NO	BAD_NO	CAVITY_NO	BOX NUMBER	MOLD WEIGHT
PROD_TAR	1000	1000	20	5	1	MD 8.8 G
CURR_NO	10111	20222	123	CNT_BAD	0	MD PCS WT
STOP_SEL	OFF	OFF	OFF	OFF	OFF	1.0 G
CNTR RES			BAD RST		RESET	

CUSHION	0.0	mm	INJ. TM	CHRG TM	CYCLE TM	
Q.C. VALUE	11.0	mm	6.00	10.0	30.0	sec
TOLERANCE	3.0	mm	1.50	2.0	2.0	sec
MEAN	0.0	mm	0.00	0.0	0.0	sec
STD DEV.	0.0	mm	0.00	0.0	0.0	sec
SELECT	OFF		OFF	OFF	OFF	

FIG. 10(PRIOR ART)

◀
CORE SETTING
▶

MOLD POS.: 0.5 mm

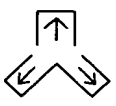

  	CORE 1	TYPE: <input checked="" type="checkbox"/> CORE	CORE-IN	CORE-OUT1	CORE-OUT2		
		SELECT	OFF	OFF	OFF		
		PRES	40	40	40	Bar	
		SPEED	40	40	40	%	
		POS.	300	0	600	mm	
		TIME	0.0	0.0	0.0	sec	
		TEETH	1	1	1	PS	
		SENSOR SW	OFF	OFF	OFF		
		TYPE: CORE					
		SELECT	OFF	OFF	OFF		
	PRES	40	40	40	Bar		
	SPEED	40	40	40	%		
	POS.	299	1	600	mm		
	TIME	0.0	0.0	0.0	sec		
	TEETH	1	1	1	PS		
	SENSOR SW	OFF	OFF	OFF			

FIG. 11(PRIOR ART)

◀
AUTO PURGE/CARR.
▶

B. INJECT POS.: 0. 0
F. INJECT POS.: 0. 0 mm

AUTO PURGE	REPEATED-SEL: <input checked="" type="checkbox"/> B. INJ REPEATED TIME: <input style="width: 50px;" type="text" value="5"/>																								
	<table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 20%;">SLOW</th> <th style="width: 20%;">FAST</th> <th style="width: 10%;"></th> <th style="width: 20%;">SUCKBACK</th> <th style="width: 20%;">CHARGE</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">40</td> <td style="text-align: center;">40</td> <td rowspan="3" style="padding: 0 10px;">PRES SPEED POS.</td> <td style="text-align: center;">40</td> <td style="text-align: center;">50</td> </tr> <tr> <td style="text-align: center;">20</td> <td style="text-align: center;">60</td> <td style="text-align: center;">30</td> <td style="text-align: center;">50</td> </tr> <tr> <td style="text-align: center;">11. 0</td> <td style="text-align: center;">30. 0</td> <td style="text-align: center;">60</td> <td style="text-align: center;">0. 0</td> </tr> <tr> <td></td> <td style="text-align: center;">mm</td> <td></td> <td style="text-align: center;">mm</td> <td style="text-align: center;">sec</td> </tr> </tbody> </table>		SLOW	FAST		SUCKBACK	CHARGE	40	40	PRES SPEED POS.	40	50	20	60	30	50	11. 0	30. 0	60	0. 0		mm		mm	sec
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	FWD	BWD																							
◀ PRES SPEED BWD-SEL ▶	40	40	Bar % ▶																						
	20	20																							
		ON																							

FIG. 12(PRIOR ART)

◀
B: INJ /CHRG SETTING
▶

CHRG LIMIT: 470.0 mm
INJ. POS.: 0. 0 mm

INJECTION USE.: ☒ OFF
SUCK MODE: ON
COOL TM: 3.0 sec

INJECT  ◀	<table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th style="width: 20%;">INJ 5</th> <th style="width: 20%;">INJ 4</th> <th style="width: 20%;">INJ 3</th> <th style="width: 20%;">INJ 2</th> <th style="width: 20%;">INJ 1</th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">20</td> <td style="text-align: center;">60</td> <td style="text-align: center;">111</td> </tr> <tr> <td>SPEED</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">20</td> <td style="text-align: center;">99</td> <td style="text-align: center;">99</td> </tr> <tr> <td>POS.</td> <td style="text-align: center;">0. 0</td> <td style="text-align: center;">*****</td> <td style="text-align: center;">10. 0</td> <td style="text-align: center;">50. 0</td> <td style="text-align: center;">96. 0</td> </tr> <tr> <td>TIME</td> <td colspan="5" style="text-align: center;">0. 00</td> </tr> </tbody> </table>						INJ 5	INJ 4	INJ 3	INJ 2	INJ 1	PRES	0	0	20	60	111	SPEED	0	0	20	99	99	POS.	0. 0	*****	10. 0	50. 0	96. 0	TIME	0. 00					Bar % mm sec
		INJ 5	INJ 4	INJ 3	INJ 2	INJ 1																														
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HOLD  ○	<table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th style="width: 20%;">HOLD4</th> <th style="width: 20%;">HOLD3</th> <th style="width: 20%;">HOLD2</th> <th style="width: 20%;">HOLD1</th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">20</td> <td style="text-align: center;">111</td> </tr> <tr> <td>SPEED</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">20</td> <td style="text-align: center;">21</td> </tr> <tr> <td>TIME</td> <td style="text-align: center;">0. 0</td> <td style="text-align: center;">0. 0</td> <td style="text-align: center;">0. 0</td> <td style="text-align: center;">0. 0</td> </tr> </tbody> </table>					HOLD4	HOLD3	HOLD2	HOLD1	PRES	0	0	20	111	SPEED	0	0	20	21	TIME	0. 0	0. 0	0. 0	0. 0	INJ. CTL MODE: <input type="text" value="POS. or TM"/> 4-CYLINDER: <input type="text" value="NORMAL-V"/>											
		HOLD4	HOLD3	HOLD2	HOLD1																															
	PRES	0	0	20	111																															
	SPEED	0	0	20	21																															
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CHARGE  ↻	<table style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th style="width: 20%;">CHRG1-BP</th> <th style="width: 20%;">CHRG2-BP</th> <th style="width: 20%;">CHRG3-BP</th> <th style="width: 20%;">POSTSCK</th> </tr> </thead> <tbody> <tr> <td>PRES</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">60</td> </tr> <tr> <td>SPEED</td> <td style="text-align: center;">0</td> <td style="text-align: center;">0</td> <td style="text-align: center;">60</td> <td style="text-align: center;">20</td> </tr> <tr> <td>SYS-PRES</td> <td colspan="3" style="text-align: center;">0</td> <td style="text-align: center;">Bar</td> </tr> <tr> <td>POS.</td> <td style="text-align: center;">0. 0</td> <td style="text-align: center;">0. 0</td> <td style="text-align: center;">60. 0</td> <td style="text-align: center;">+ 99 mm</td> </tr> </tbody> </table>					CHRG1-BP	CHRG2-BP	CHRG3-BP	POSTSCK	PRES	0	0	0	60	SPEED	0	0	60	20	SYS-PRES	0			Bar	POS.	0. 0	0. 0	60. 0	+ 99 mm	Bar % Bar mm						
		CHRG1-BP	CHRG2-BP	CHRG3-BP	POSTSCK																															
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POS.	0. 0	0. 0	60. 0	+ 99 mm																																

FIG. 13(PRIOR ART)